

Please cut Feb 29 or Mar 1

Work Order ID 139085

139085

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Tuesday, February 09, 2016 1:45:34 PM

Item ID: D3303-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket
 Start Date: 11/13/2015 Start Qty: 6.00 *6* 12 SH
 Required Date: 11/13/2015 Req'd Qty: 6.00 *6* 12 SH
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: MLJ Date: FEB 09 2016 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3303	Rev B								
100	FLOW WATER JET	0.00							
100	Waterjet	0.02				(15)			pc 16/02/29
	Memo								
	FLOW CNC Waterjet								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110	QC	0.00				(15)			pc 16/02/29
	Memo								
	Quality Control								
120	QC8- Inspect parts - second check	0.00							
120	QC	0.00				(15)			
	Memo								
	Quality Control								

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Work Order ID 139085

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Tuesday, February 09, 2016 1:45:34 PM

Item ID: D3303-3 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Bracket

Start Date: 11/13/2015 Start Qty: 6.00 *6* Cust Item ID:

Required Date: 11/13/2015 Req'd Qty: 6.00 *6* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130	Small Fab	0.00				15x			16/03/02
Small Fab	Memo								
Small Fab	1- Deburr2- C'sink nut plate holes as per Dwg D33033-polish waterjet marks								
140	NC BRAKE	0.00							
140	Brake NC	0.01							
Brake NC	Memo								
Brake NC	Form as per Dwg D3303 to fit DT9011								
150	QC5- Inspect part completeness to step on W/O	0.00							
150	QC	0.00							
Quality Control	Memo								

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MAR 04 2016

Work Order ID 139085

139085

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Tuesday, February 09, 2016 1:45:34 PM

Item ID: D3303-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 11/13/2015 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 11/13/2015 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00				15		16-3-8	
160	HandFinish	0.00							
Hand Finishing	Memo								
170	QC7-Inspect Chemical Conversion Coat	0.00				(15)			DAS 38 9-89
170	QC	0.00							MAR 08 2016
Quality Control	Memo								
180	Identify as per dwg & Stock Location: <u>Stacy</u>	0.00				15			DAS 6 9-89
180	Packaging	0.00							MAR 08 2016
Packaging	Memo								

Work Order ID 139085

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139085

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Item ID: D3303-3

Revision ID:

Item Name: Bracket

Start Date: 11/13/2015 Start Qty: 6.00

Required Date: 11/13/2015 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.01

Quality Control

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Run Start ***NR1***Stop ***NR2***

MCS MAR 10 2016

MCS MAR 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

DART AEROSPACE LTD		Work Order:	139085
Description: Head Rest		Part Number:	D3303-3
Inspection Dwg: D3303	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.850	+/-0.010	4.851	/		V.D. 02	
4.330	+/-0.005	4.329	/		Tap	
0.550	+/-0.010	.55	/			
0.260	+/-0.010	.258	/			
3.300	+/-0.010	3.300	/			
1.500	+/-0.005	1.498	/			
0.250	+/-0.005	.249	/			
Ø0.219	+0.005/-0.000	Ø.220	/			
Ø0.098	+0.005/-0.000	Ø.100	/			
Ø0.128	+0.005/-0.000	Ø.131	/			
R0.12	+/-0.030	.12	/			
2.000	+/-0.005	1.997	/			
1.425	+/-0.010	1.427	/			
8.100	+/-0.010	8.104	/			
1.000	+/-0.005	.998	/			
0.040	+/-0.010	.038	/			

Measured by:	<i>DK</i>	Audited by:	DAS 38	Prototype Approval:	N/A
Date:	16/02/29	Date:	9-89 MAR 01 2016	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.08	New Issue	KJ/JLM	
B	08.05.07	Dimensions updated per Dwg Rev B	KJ/DD	

Picklist Print

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Page 1

Work Order ID: 139085

139085

Parent Item: D3303-3

D3303-3

Parent Item Name: Bracket

Start Date: 11/13/2015

Required Date: 11/13/2015

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP: A04.09.07New issueKJ/JLM

IPP Rev:B 08-05-13 add DT9011 jig DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	112.6400	0.2986	1.885895			

M2024T3S 040

2024-T3 .040 sheet

Dr 16/03/01

Location

Loc Qty

Loc Code

MAT022

112.64

m13235

34

m133548

30.64

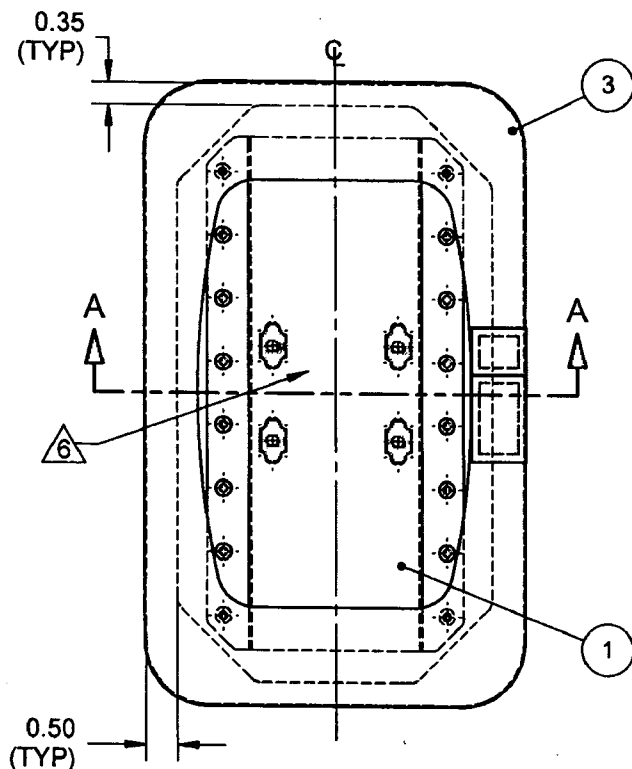
m134157

48

4.6



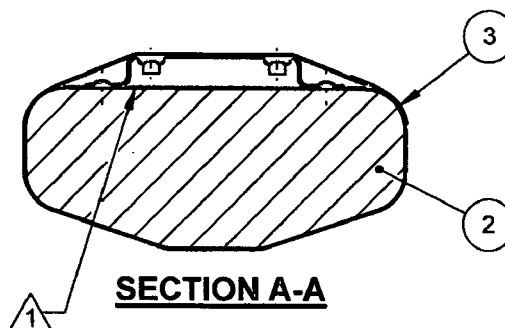
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 1 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:3
REV	DATE	DESCRIPTION	
A	04.08.18	NEW ISSUE	
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE	



RELEASED

06-09-19 *[Signature]*

DEO ATTACHED



D3303-041 HEAD REST

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

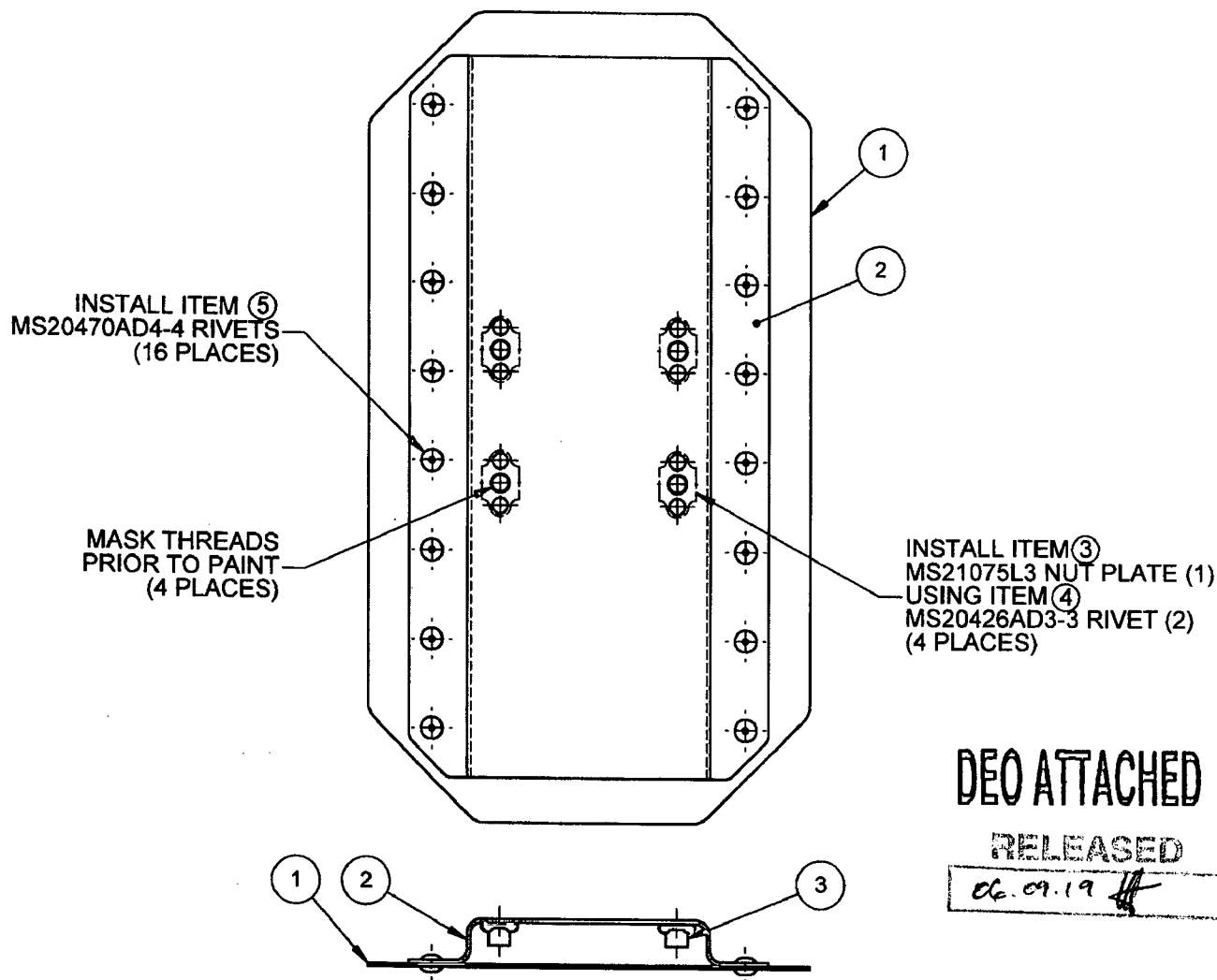
SUPPLY
 PARTS TO
 IDENTIFY
 INFORMATION
 START COPY
 WITH COPY
 139085 NLS
 15/1-18

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DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3303	REV. B SHEET 2 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



DEO ATTACHED

RELEASED

06.09.19 *PH*

D3303-043 BRACKET ASSEMBLY

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

NOTES:

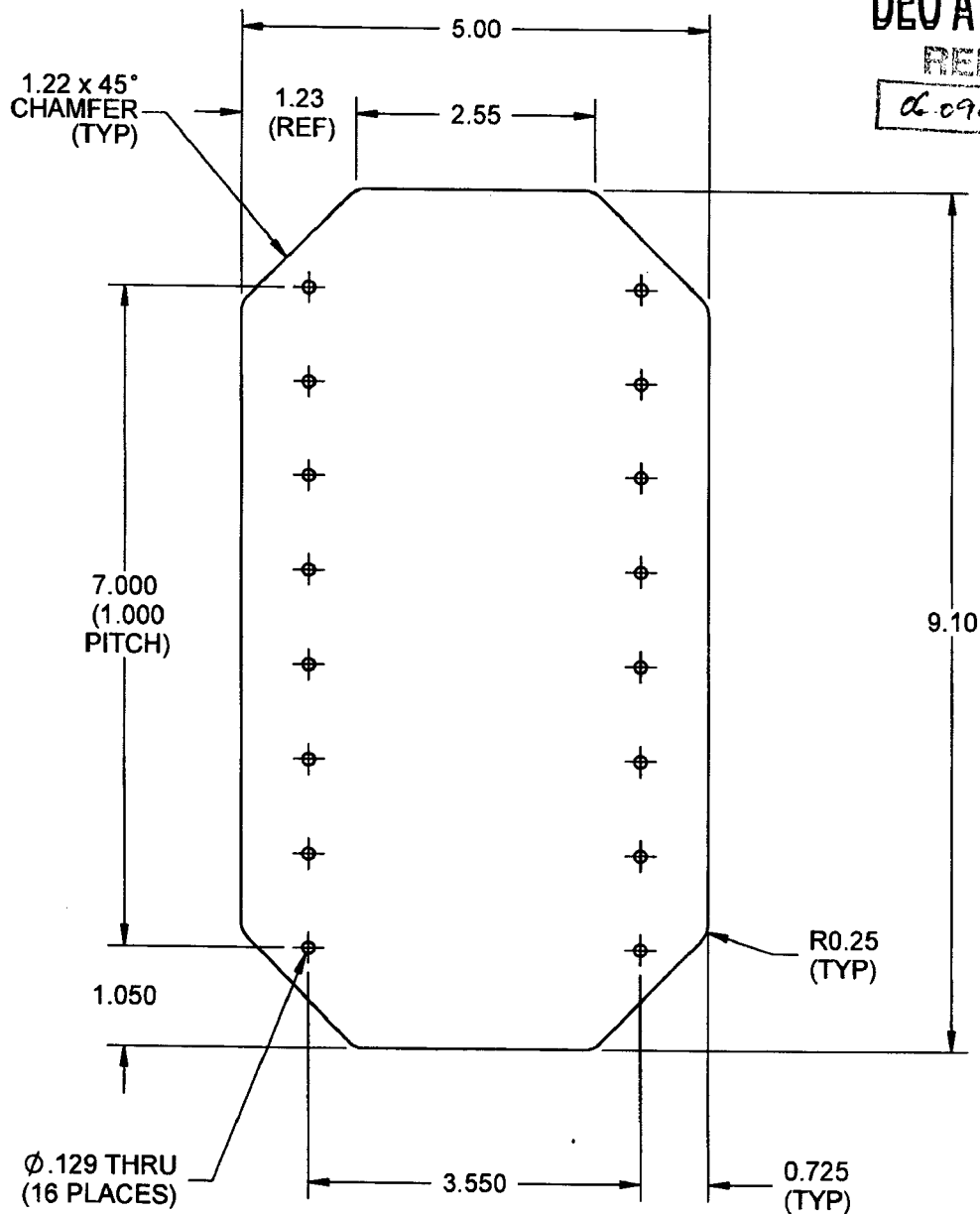
- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 3 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



DEO ATTACHED

RELEASED

09.14 *[Signature]*

D3303-1 PLATE

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

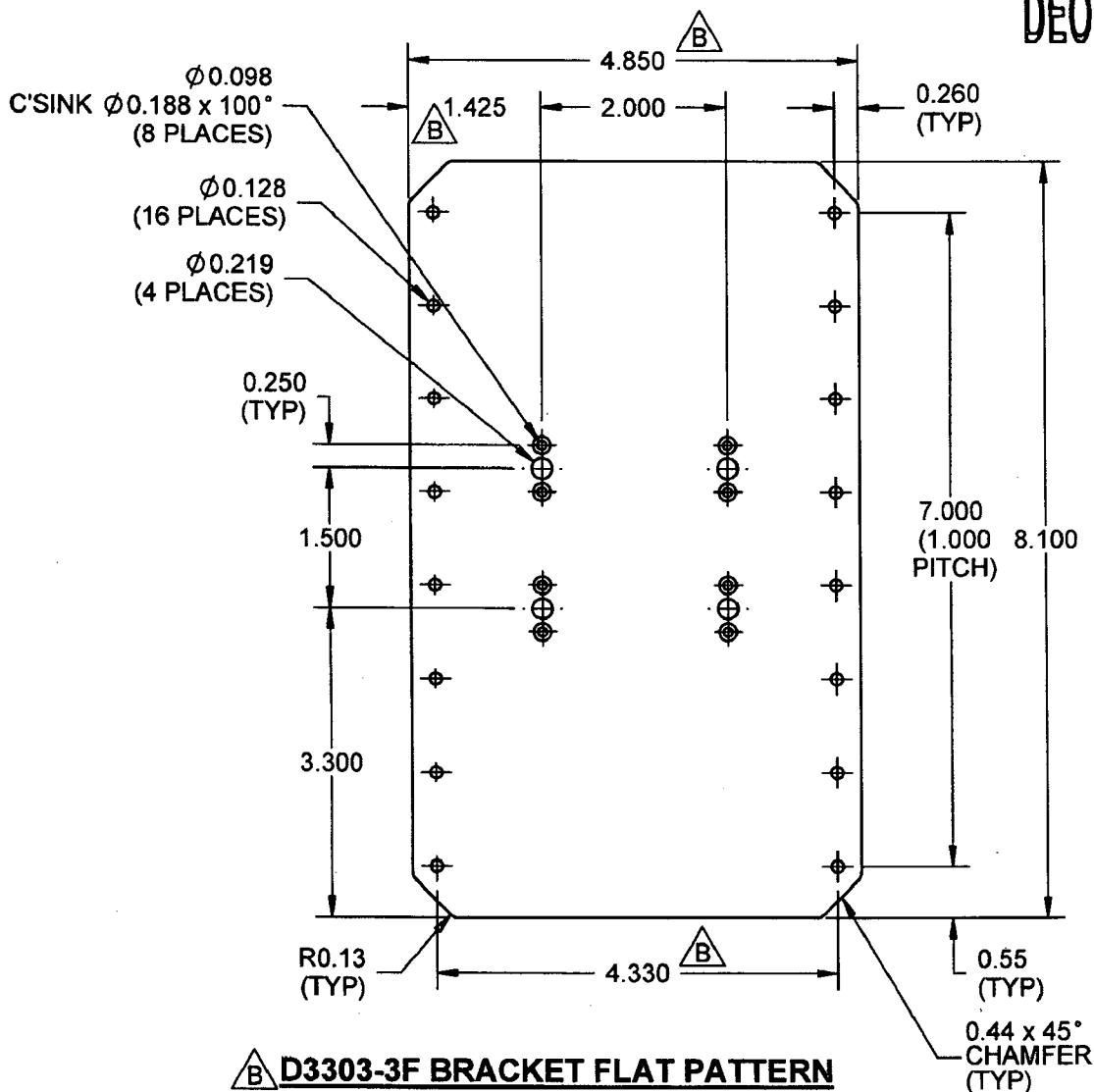
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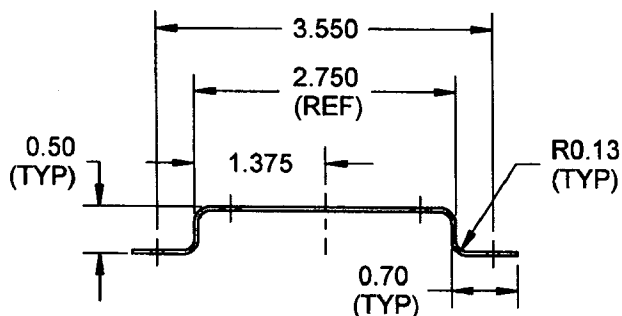


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 4 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2

DEO ATTACHED



D3303-3F BRACKET FLAT PATTERN



D3303-3 BRACKET BEND DETAIL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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DRAWING NO. D3303	TITLE HEAD REST	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3303-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>h</i>	MFG. APPR. <i>h</i>	APPROVED <i>h</i>	DE APPR. <i>h</i>			
DATE 08.10.15	DATE <i>08.10.15</i>	DATE <i>08/10/16</i>	DATE <i>08/10/16</i>	DATE <i>08/10/16</i>			

SHEET 1 ADD 1300L ADHESIVE BY 3M TO NOTE 1 AS FOLLOWS:

IS:

NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 OR 1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

WAS:

NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

SEE NCR 08-069 FOR FURTHER DETAILS

RELEASED
08/11/16